

Date: Monday, 11/14/2005 2:25:53 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ADJUSTABLE ENGINE MOUNT KIT (205)
Job Number : 24761	
Estimate Number : 10548	
P.O. Number :	Part Number : D205708011
This Issue : 11/14/2005 S.O. No. :	Drawing Number : B80701 REV C
Prsht Rev. : NC	Project Number :
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run :	Material :
Written By :	Due Date : 11/30/2005 Qty: 10 Um: Each
Checked & Approved By :	
Comment : Est B 04.11.01 Assembly no longer made in-house KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

2.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000096 for:

6	D3284-001	Sleeve
2	D3284-003	Stud
4	D3284-005	Stud
6	D3284-007	Stud
6	NAS509-12	Nut
6	NAS509L12	NutStud

u 05/11/14

To be assembled as per Dwg B80701 Rev. C

Possible Supplier: Northern Aero

Certificate of Conformity is required

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure Certificate of Conformity is attached

C Loc 10/1/09 10

Date:
User:

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect assembly. Visually inspect thread, fit and cad plating

u 06-01-09

5.0

D3284001

Sleeve



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-001 Sleeve

B24761

6.0

D3284003

Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Stud

Pick:

Packing Kit (Note: (1) D205-708-011 Kit includes all parts listed below)

Qty Part Number Description Batch

2 D3284-003 Stud

B24761

7.0

D3284005

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty Part Number Description Batch

4 D3284-005 Stud

B24761

8.0

D3284007

Stud



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Stud

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty Part Number Description Batch

6 D3284-007 Stud

B24761

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Job Number: 24761

Part Number: D205708011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D3284009	Bearing
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Bearing

Pick:

Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
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6	D3284-009	Bearing	B24311 8mcp
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B24775-2 27mcp

B24735-4 25mcp

10.0	D3284011	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bearing

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty	Part Number	Description	Batch
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1	D3284-011	Bearing	B24776-3 mcp
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B24312A 1 mcp

B24312B 6 mcp

11.0	MS206136C16	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

Kit includes all parts listed below)

Qty	Part Number	Description	Batch
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8	MS20613-6C16Rivet	M19098	
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M19098

12.0	MS206136C18	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
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8	MS20613-6C18 Rivet	M17546	17456
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M17546 41mcp

M17349 39mcp

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	MS206136C19	Rivet
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Rivet

Pick: Packing Kit (Note: (1) D205-708-011

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
8	MS20613-6C19	Rivet	M/6255

14.0	NAS50912	Nut
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509-12	Nut	B 24761

15.0	NAS509L12	Nut
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Pick: Packing Kit (Note: (1) D204-708-013

(Kit includes all parts listed below)

Qty	Part Number	Description	Batch
6	NAS509L12	Nut	B 24761

16.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-708-011

Location: _____

PPP Rev: 9

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Job Number: 24761

Part Number: D205708011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/13 (10)

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 14, 2005
02:29 pm

Work Order No	: 0024761	Department Code:	
Project Name	: D205-708-011	Burden Flags	: NNNNNNNN
Project For	: WK548	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: *D205-708-011	Invoice Number	:
Description	: Adjustable Engine Mount	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 10	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-14-05		
Est Finish Date	: 11-30-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

1. Approving national aviation authority / country TRANSPORT CANADA		2. AUTHORIZED RELEASE CERTIFICATE TCCA 24-0078			3. Form tracking No. SO12468-1	
4. Approved organization name and address AMO 88-97		5. NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada			5. Work Order/Contract/Invoice PO 00000096	

6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work
1	SLEEVE (D3284001)	B80702-1	BELL 204	27	05-2315	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..
2	SLEEVE (D3284001)	B80702-1	BELL 204	60	06-1002	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..
3	SLEEVE (D3284001)	B80702-1	BELL 204	37	06-1013	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..
4	3/4 STUD (D3284005)	B80704-1	BELL 204	63	05-2583	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..

13. Remarks
THESE AERONAUTICAL PRODUCTS CONFORM TO APPROVED DESIGN DATA IN ACCORDANCE WITH TRANSPORT CANADA
STC SH99-11 (FAA STC SR00953NY & SR01395NY).

APPLICATION OF MIL-PRF-16173, Gr. I CORROSION PREVENTATIVE COMPOUND ON THE FINAL INSTALLATION OF THESE PARTS IS THE
RESPONSIBILITY OF THE INSTALLER.

14. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 13.		<div style="background-color: #cccccc; padding: 5px;"> 19. <input type="checkbox"/> CAR 571-10 Maintenance Release <input type="checkbox"/> Other regulations specified in block 13 Certifies that, except where otherwise specified in block 13 the work identified in block 12 and described in block 13 was performed in accordance with CAR 571. </div>	
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15. Authorized Signature 	16. Certificate / Approval Ref. No. AMO 88-97	20. Authorized Signature N/A	21. Certificate / Approval Ref. No. N/A
17. Name R. D. Williamson	18. Date (DD MMM YYYY) 06 JANUARY 2006	22. Name N/A	23. Date (DD MMM YYYY)

INSTALLER RESPONSIBILITIES

*Installer must cross-check eligibility with approved data.

This document does not constitute authority to install the part.

Where the installer works in accordance with the national regulations of an airworthiness authority other than the authority specified in block 1, the installer must ensure that his/her airworthiness authority accepts products or maintenance from the airworthiness authority specified in block 1.

Statements 14 and 19 do not constitute installation certification. In all cases, the aircraft technical record must contain an installation certification, issued in accordance with the national regulations of the state of registry, before the aircraft may be flown.

1. Approving national aviation authority / country TRANSPORT CANADA		2. AUTHORIZED RELEASE CERTIFICATE TCCA 24-0078				3. Form tracking No. SO12468-2	
4. Approved organization name and address AMO 88-97		NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada				5. Work Order/Contract/Invoice PO 00000096	

6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work
5	3/4 STUD (D3284005)	B80704-1	BELL 204	3	05-1892	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..
6	3/4 STUD (D3284005)	B80704-1	BELL 204	34	06-1011	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..
7	7/8 STUD (D3284007)	B80705-1	BELL 204	25	05-2274	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..
8	7/8 STUD (D3284007)	B80705-1	BELL 204	95	06-1001	Manufactured
-	-	-	205 AND	-	-	..
-	-	-	UH-1H	-	-	..

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17. Name R. D. Williamson	18. Date (DD MMM YYYY) 06 JANUARY 2006	22. Name N/A	23. Date (DD MMM YYYY)

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4. Approved organization name and address AMO 88-97		NORTHERN AERO INDUSTRIES LTD. 1845 St. Matthews Avenue Winnipeg, Manitoba R3H 0A8 Canada			5. Work Order/Contract/Invoice PO 00000096	

6. Item	7. Description	8. Part No.	9. Eligibility*	10. Qty.	11. Serial/Batch No.	12. Status/Work
9	7/8 STUD (D3284003)	B80703-1	BELL 205 UH-1H	20	05-2276	Manufactured
-	-	-	-	-	-	..
-	-	-	-	-	-	..
10	NUTS	NAS509-12	various	73	05-1700	Manufactured
11	NUTS	NAS509-12	various	47	05-2618	Manufactured
12	NUTS	NAS509-L12	various	35	05-1551	Manufactured
13	NUTS	NAS509-L12	various	85	05-2535	Manufactured
						..
						..
						..
						..

13. Remarks
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